



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246



D5853-043
Job Sheet 207569



Part No: D5853-043

Job Qty: 4 pcs

Part Name: Basket Rim Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/27/20

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 4/27/20

Description:

Type: Stock

Note: URF 20-522 DWG D5853 Rev A IPP Rev. A 2020.01.30 New issue DP Verify DD

Ship Via:

POSITIVE RECORD

EFFECTIVE 3/13/20 AUTH: MRC

RELEASED DATE

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	4 pcs	4/27/20	4/27/20	0.00	0.80	Large Fab - 1		MRC
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
160	QC 5	4 pcs	4/27/20	4/27/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Container No: S263925



Part: D5853-043

Job No: 207569

Serial No/Batch: S263925

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/16/20

DAS
40
9-89

MAR 17 2020

170 Packaging 3-1 - Stock - B4B 4 pcs

4/27/20

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

Packaging 3 - 37 - B4B

180 QC 21 - SA

4 pcs

4/27/20

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

MAR 17 2020

Part Op 100 - 1- Cut as per dwg D5853-3 2-Drill holes with DT10653 as per dwg D5853-3 ***DRILL ONE SIDE*** 3-Deburr.
 Descriptions: ***Note that the welding and back drilling of support D5853-7 will be done on top level weldment to accommodate welding fixture.***

160 - QC5- Inspect part completeness to step on W/O ***Welding will be done on top level weldment***

170 - Identify as per dwg & Stock Location: W/O 4 As per drawing, see note 6.

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NTS0.750W.035	4130 Square Tube 0.750 X 0.035W	8.5600 ft (2.14 ea)	100-Large Fab - Basket - 1	5250794

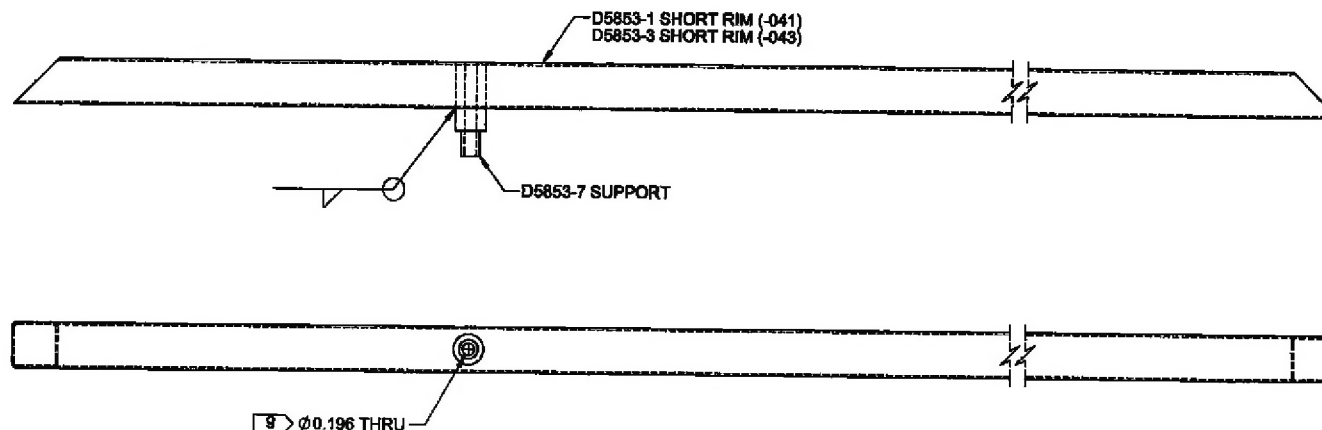
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	M4130NTS0.750W.035	9	324	0

Part Specifications

Specifications could not be found.

QTY -041	QTY -043	P/N	DESCRIPTION
X		D5853-041	BASKET RIM WELDMENT
	X	D5853-043	BASKET RIM WELDMENT
1		D5853-1	SHORT RIM
	1	D5853-3	SHORT RIM
1	1	D5853-7	SUPPORT



D5853-041 BASKET RIM WELDMENT
D5853-043 BASKET RIM WELDMENT

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 207569

RELEASED

2020 FEB 18 *ND*
 ECN 2020-521

ML5
2003-12

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 7) WEIGHT: -041: 0.65 lbs
 -043: 0.73 lbs
 8) WELD PER DART QSI 004
 9) DRILL THRU SUPPORT AND TUBE AFTER WELDING.

UNDER REVIEW
 URF 2020-522 20.02.14 (NO)

A	NEW ISSUE	ZF	20.01.24
REV.	DESCRIPTION	BY	DATE
DESIGN	ZF		
DRAWN	ZF		
CHECKED	KPT		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	CP		
DATE	20.01.24		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D5853

TITLE

BASKET RIM

REV. A

SHEET 1 OF 6

SCALE

NTS

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045594



Supplier: FAC001-VU
Factory Steel
14020 Oakland Ave.
Detroit, MI 48203 USA
Phone: 313 883 6300
Fax: 313 883 4883

PO No: POHB045594

PO Date: 1/16/20

Due Date: 2/4/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

JAN 16 2020

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		M4130NTS0.750W.035			4130 Square Tube 0.750 X 0.035W : MATERIAL: AISI 4130N STEEL SQUARE TUBING PER ONE OF THE FOLLOWING SPEC'S: MIL-T-6736, AMS 6371, 6390, 6361, 6362, 6373 OR 6374	Firmed	-	2/4/20	600 ft	0 ft	600 ft	\$7.25/ft	\$4,350.00
2		M4130NTS1.000W.065			4130 Square Tube 1.000" X 1.000" X 0.065"W : MATERIAL: AISI 4130N STEEL SQUARE TUBING PER ONE OF THE FOLLOWING SPEC'S: MIL-T-6736, AMS 6371, 6390, 6361, 6362, 6373 OR 6374	Firmed	-	2/4/20	160 ft	0 ft	160 ft	\$11.70/ft	\$1,872.00
												Grand Total: \$6,222.00	

Plex 1/16/20 11:38 AM Dart, Levoie, Chantal

PACKING LIST

No. 67371

PG 1 OF 1

FACTORY STEEL & METAL SUPPLY
14020 OAKLAND AVENUE
DETROIT, MI 48203

(313)883-6300 PHONE
(313)883-4883 FAX

SOLD TO
DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

CUSTOMER PO
POHBO45594
CUSTOMER JOB

SALES ORDER
60306

ORDER DATE
01/16/2020

SHIP TO
DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

BUYER
CHANTEL LAVOIE
Tel (613) 632-3336
Fax (613) 632-4443

SALES REP
MICK HALON

SHIP INST
CALL WHEN READY

PRO#

TERMS
NET 30 DAYS

SHIP DATE
01/21/2020

SHIP VIA
****TRUCK****

RESALE #
59-2958719

CARRIER
TRUCK

BLIND Y/N
N

FOB
DETROIT

LINE	QUANTITY	DESCRIPTION	WIDTH	LENGTH	WEIGHT
1	609.917 FT	4130N CD SMLSS SQ TUBE 3/4" X .035W Tag Mill Ref # Heat 153513 023679 616506	Pcs Length 26 20' / 24' RL	20' / 24' RL Feet 609.917	207.554 Weight 207.554
2	171.333 FT	4130N CD SMLSS SQ TUBE 1" X .065W Tag Mill Ref # Heat 153514 072143 072067859	Pcs Length 7 22' / 23' RL	22' / 23' RL Feet 171.333	141.606 Weight 141.606
3	1 PCS	PACKING CHARGES MTRS (CIRCLE) FAX SHIPMENT INVOICE ALL - DATE: _____ INITIAL: _____			

TOTAL WT
349 LBS

RECEIVED BY - SIGNATURE

RECEIVED BY - PRINTED NAME

DATE RECEIVED

LIWEI

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M4130NTS 0.750W.035 PO / BATCH NO.: POM13045594
 DATE: JAN 27 2020 5250794

MATERIAL CERT REC'D: YES
 QUANTITY RECEIVED: 609 PT
 QUANTITY INSPECTED: 609 PT
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .750W.035
 THICKNESS RECEIVED: .750W.035
 SHEET SIZE ORDERED: —
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(Y) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(Y) N	
CORRECT MATERIAL PER M-DRAWING	(Y) N	MIL-T-6736
CORRECT THICKNESS	(Y) N	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	(Y) N	616506
CORRECT MATERIAL IDENTIFICATION	(Y) N	
CORRECT M# ON THE MATERIAL	(Y) N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (Y)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u>	SIGNED OFF BY: <u>32</u>		
DATE: <u>JAN 27 2020</u>	DATE: <u>0.89</u>		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

LIVE 1
M4130NTS 0.750W.035

S250794

616506



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. M4130N-TS	REV. A SHEET 1 OF 1
DATE 05.02.09		TITLE 4130N SQUARE TUBING	SCALE NTS
A	05.02.09	NEW ISSUE	

PURCHASE MATERIAL:

AISI 4130N STEEL SQUARE TUBING PER ONE OF
THE FOLLOWING SPEC'S: MIL-T-6736 AMS 6371,
6360, 6361, 6362, 6373 OR 6374

DAS
82
9-89

PART NUMBER:

M4130N-TS | A.AAA | W | .TTT |

WHERE A.AAA = WIDTH IN INCHES
TTT = WALL THICKNESS IN INCHES

EXAMPLE: 0.50" X 0.035" WALL = M4130N-TS0.500W.035

RELEASED
05.02.09 PH

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PLYMOUTH TUBE CO.

1200 East 12th Street, Detroit, Michigan 48204
Phone: (313) 673-1615 Fax: (313) 673-7343

TRUST YOUR SOURCE ACCEPT NO SUBSTITUTION



PRODUCT CERTIFICATION

SALES ORDER - LINE / RLS

175629 - 1 / 0

SHIP TO

Factory Steel & Metal Supply C
14020 Oakland Avenue
Detroit, MI 48203
USA

WORK ORDER 023679

PCS/HEAT 0

HEAT NUMBER 616506

MELT SOURCE Beneler Steel & Tube-Germany

CUSTOMER P.O. 3887	CUSTOMER PART SQ-N34035	QUANTITY	LADING NO	CERT ID / REV /	CERT DATE								
PART DESCRIPTION SHSQ0750035J300 ***** Square OD ***** Side1: 0.7500 Max:0.7600 Min:0.7400 Side2: 0.7500 Max:0.7600 Min:0.7400 Wall: 0.0350 Max:0.0380 Min:0.0320 Length: 10.00/26.00 Spec: MIL-T 6736B Seamless Aircraft Grade: 4130 Anneal: Cond N													
CERTIFICATION REQUIREMENTS FAR BAA (FAR 52.225-1 Buy America Act Supplies), DFARS 252.225-7001 Buy America Act & Bal. of Payments Program FAR TAA (FAR 52.225-5 Trade Agreements)(Paragraph 1,3,4,5)This material was fully tested and conforms to the requirements of ASTM A-450. The Grain size is determined and reported by the raw material supplier in accordance to ASTM E-112. This raw material was magnetic particle inspected by the raw material supplier in accordance to AMS 2640J and/or ASTM E-1444, and rated as Frequency, and Severity to AMS 2301, latest revision. Yield is determined by using the 0.2% offset method. Additional Specifications - AMS-T 6736B, 6380P & 6371L. Material produced in accordance to ASTM A-519-17 and MIL-T 6736B. This material meets Plymouth Product specifications. Jominy results: J(5/16")=45 J(8/16")=38													
Chemical Analysis													
C	Mn	P	S	Si	Al	Cr	Mo	Ni	Nb	Cu	V	Ti	Sn
.310	.55	.011	.002	.230	.035	.87	.18	.12	.001	.16	.002	.002	.010
Physical Properties													
Freq.	Severity	Grain Size											
.020	.015	9											
Mechanical Properties													
TEST	UNITS	#TESTS	HIGH	LOW	AVERAGE	STD-DEV							
Tensile	Psi	6	126660	125480	126066	482							
Yield	Psi	6	120930	119880	120387	374							
Elongation	%	6	21	20	20	1							
Rockwell C	Rc	6	25	25	25	0							
TEST	RESULT												
Decarb/OD	Pass												
Total ID/OD decarb	Pass												

I certify that the results are a true and correct copy of the records prepared and maintained by Plymouth Tube Company, Streater in compliance with the requirements of the cited specification. Chemistry is as reported by the Steel supplier. This test report cannot be reproduced or distributed except in full without the written permission of Plymouth Tube.

Janet Drossel
Quality Assurance

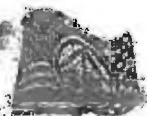
11



PLYMOUTH TUBE CO.

1208 East 12th Street, Streator, Illinois 61353
Phone: (815) 873-1818 Fax: (815) 872-7443

TRUST YOUR SOURCE. ACCEPT NO SUBSTITUTION.



PRODUCT CERTIFICATION

SALES ORDER - LINE / RLS

175629 - 1 / 0

SHIP TO

Factory Steel & Metal Supply C
14020 Oakland Avenue
Detroit, MI 48203
USA

WORK ORDER 023679

HEAT NUMBER 616506

MELT SOURCE Benteler Steel & Tube-Germany

PCS/HEAT 0

CUSTOMER P.O.	CUSTOMER PART	QUANTITY	LOADING NO	CERT ID / REV	CERT DATE
3887	SQ-N34035			/	

PART DESCRIPTION SHSQ0750035J300

Additional Specification(s)

TEST	UNITS	#TESTS	HIGH	LOW	AVERAGE	STD-DEV
Brinell	Brinell	6	253	253	253	0

This test report data is for the heat Chemistry Stated above.

The material in this test report is:

- 1) Drawn in the USA
- 2) Free from Polybrominated Biphenyls (PBB), Polybrominated Diphenyl Ethers (PBDE), and Mercury contamination.
- 3) NAFTA compliant.

End of Certification

I certify that the results are a true and correct copy of the records prepared and maintained by Plymouth Tube Company, Streator in compliance with the requirements of the cited specification. Chemistry is as reported by the Steel supplier. This test report cannot be reproduced or distributed except in full without the written permission of Plymouth Tube.

James J. Dressel
Quality Assurance

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator	
Root Cause Operator <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Presservation <input type="checkbox"/> Material <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Human Factors <input type="checkbox"/>		FAULT CATEGORY <div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
		Other/Details:			